

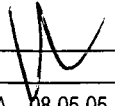
Feq BU 16/01

Dart Aerospace Ltd.

Date: Friday, 09/01/2009 1:35:39 PM
User: Linda Lacelle

Process Sheet












SPLIT-

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUSHION ASSEMBLY
Job Number : 44535	
Estimate Number : 13303	
P.O. Number :	Part Number : D3781041
This Issue : 09/01/2009 S.O. No. :	Drawing Number : D3781 REVC PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : PRELIM
Previous Run : 40732	Material :
Written By : 	Due Date : 30/01/2009 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-05 new issue DD verified by:EC Est Rev:B 08-07-22 revB as per dwg DD verified by:EC Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec	



Additional Product

PRELIMINARY ISSUE

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D37811	Supporting Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Supporting Plate			
2.0	MS20426AD34	RIVET	
			
Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s) RIVET			
3.0	MS21075L3	Nutplate	
			
Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s) Nutplate			
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install nut plate and rivet as per dwg D3781			
5.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			

40734

N/A done
or D3781-1

NEERING
PROVAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.01.30	2-34-7	Remove steps 2-34-7 done on est 13248-D3781-1 Add D3781-041P to pull when rec'd	<i>[Signature]</i>	09.01.30 09.02.18		<i>[Signature]</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 1:35:39 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION ASSEMBLY

Job Number: 44535

Part Number: D3781041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

7965

0209/01/14

8

Ship with D3781-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-11. BOND FABRIC USING 3M ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

7.0

D37813

Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

CUSHION

BATCH:

PLA ~

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

0209/01/30

① ship @ Eagle.

9.0

QC6

DIMENSIONAL CHECK



ENGINEERING
APPROVAL



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3781

INSPECTED BY DS/H5

09.02.17 SEE ATTACHED

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

rec'd at Eagle
see 2th sheet

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



POSITIVE RECALL

EFFECTIVE 02/09

RELEASED

AUTH

DATE

09.02.17

11.09.01.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

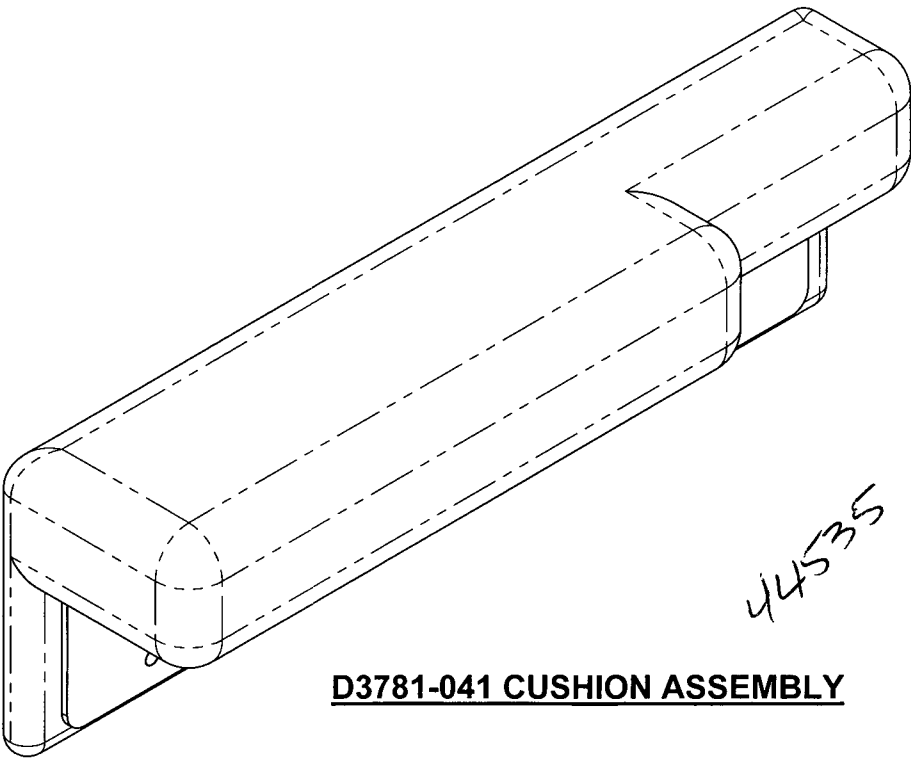
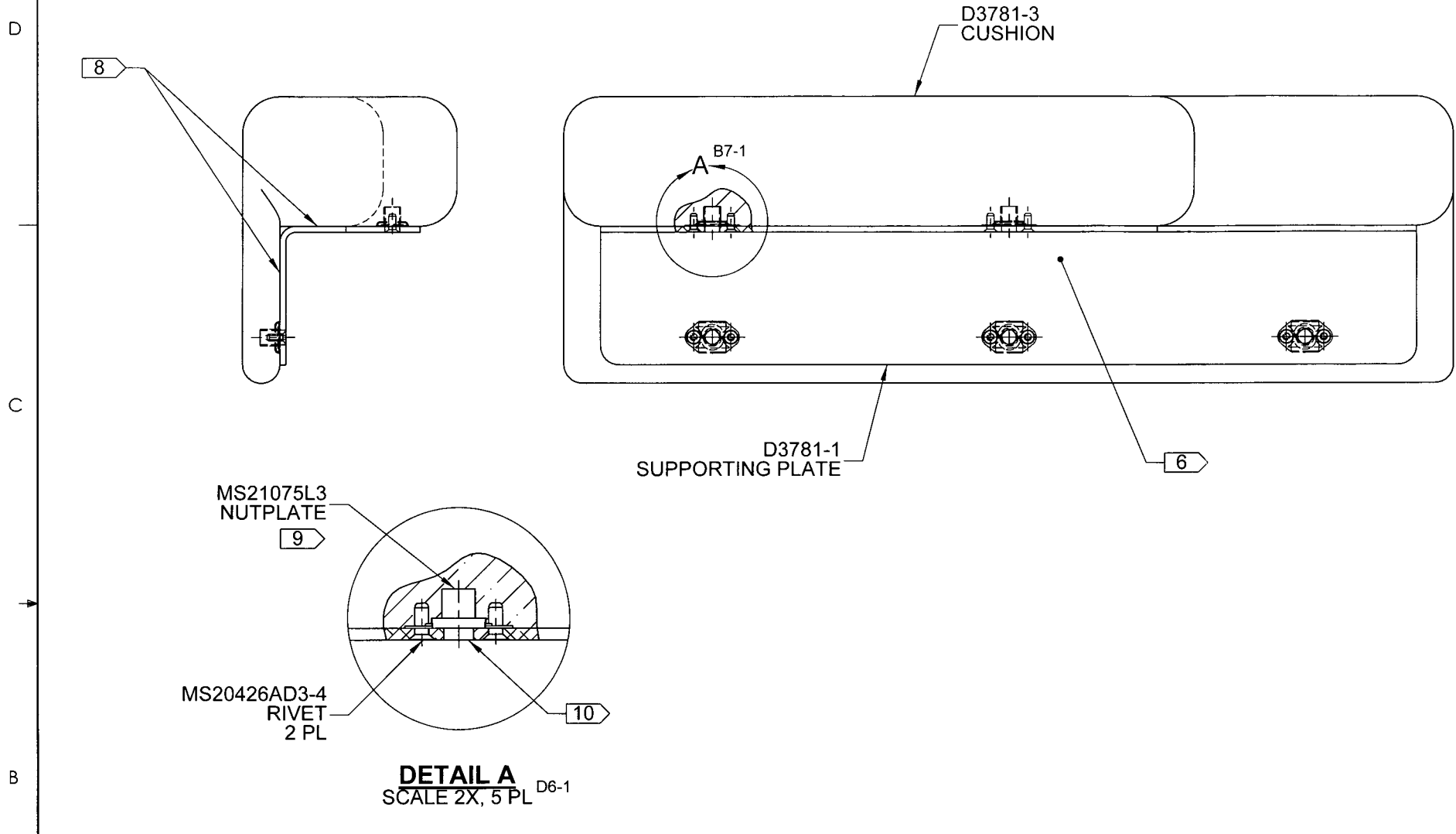
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
13	1	D3781-3	CUSHION
21	10	MS20426AD3-4	RIVET
22	5	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE

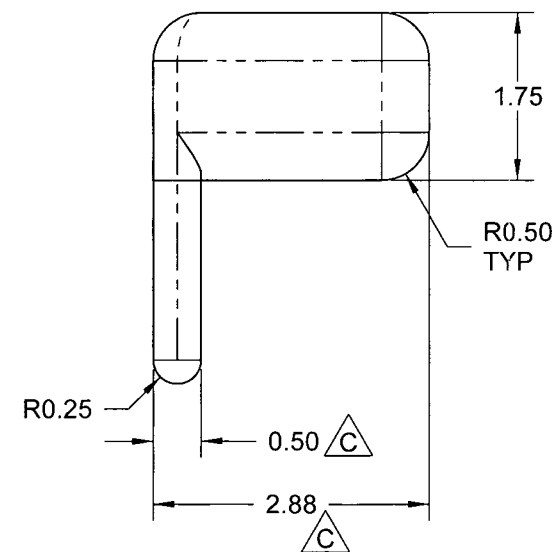
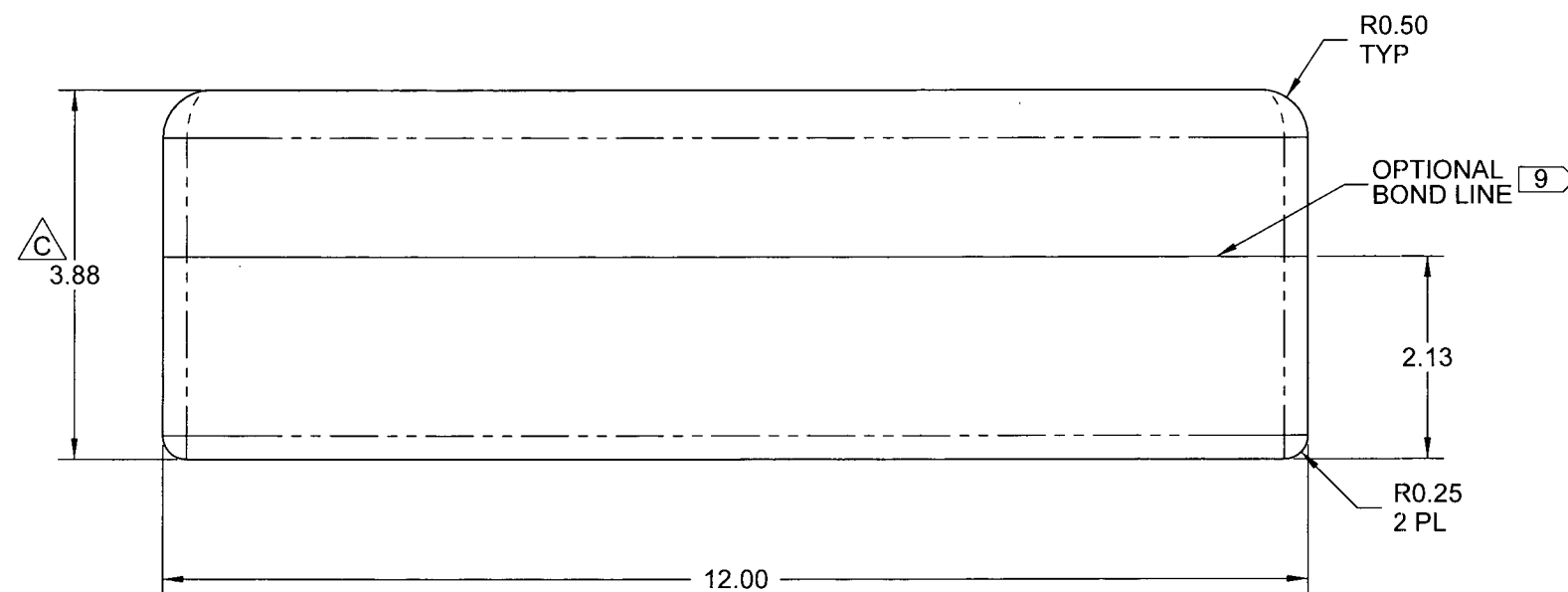
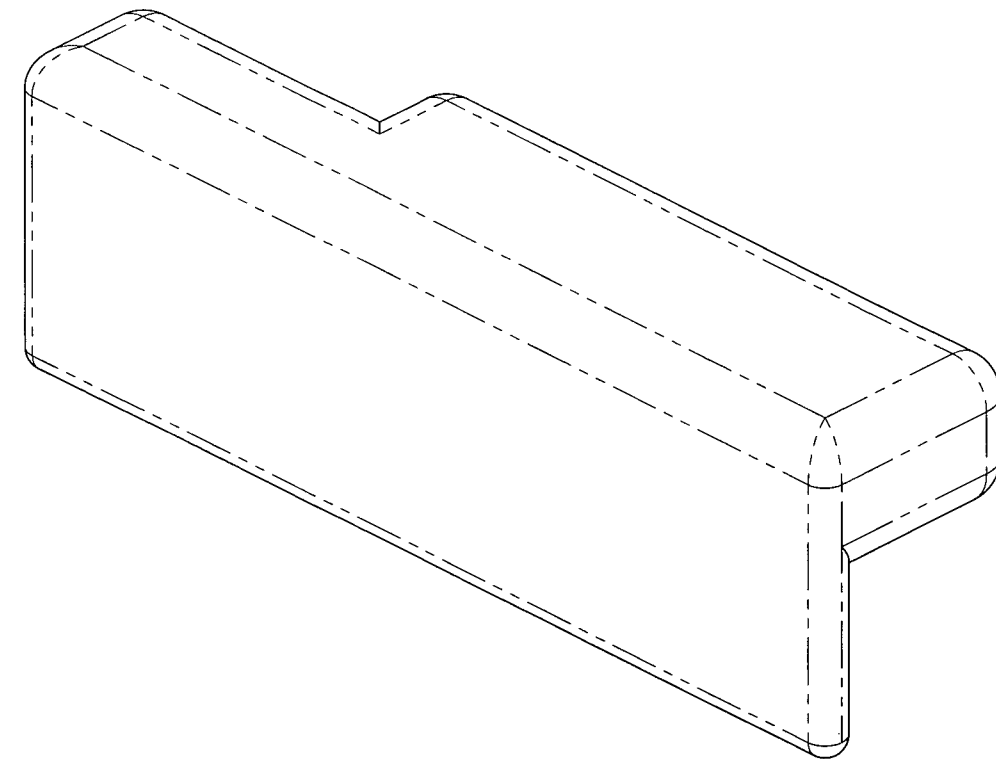
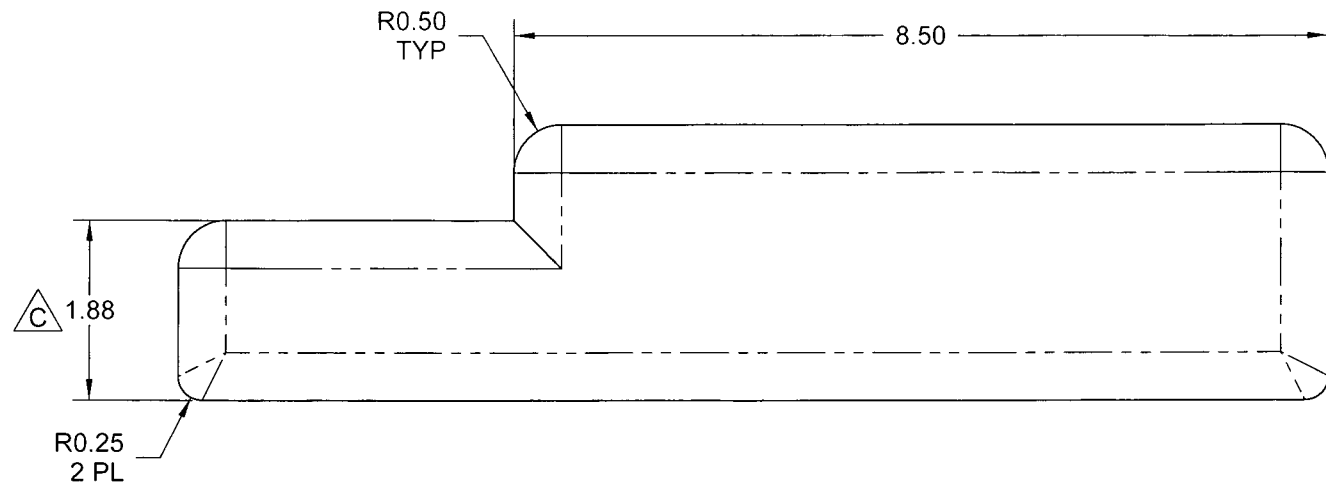


D3781-041 CUSHION ASSEMBLY

PRELIMINARY ISSUE
209.01.14 REF. ECU 09-302P

- D3781-041 NOTES:
- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.65 lbs
 - 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
 - 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3781	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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D3781-3 CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 1.75" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN ABOVE USING 3M 1300 SCOTCH-BRITE ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

PRELIMINARY ISSUE

44535
09.01.14
REF. ECN 409-502P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3781	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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09/01/2009 1:35:39 PM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION ASSEMBLY

Job Number: 44535

Part Number: D3781041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 7965

09/01/14

8

Ship with D3781-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-11. BOND FABRIC USING 3M ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

7.0

D37813

Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

CUSHION

BATCH: _____

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

09/01/30

1 ship @ Eagle.

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3781

ENGINEERING
APPROVAL

MATERIAL OK
DIMENSIONS ACCEPTABLE

09.02.02

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FINAL INSPECTION/W/O RELEASE

11.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

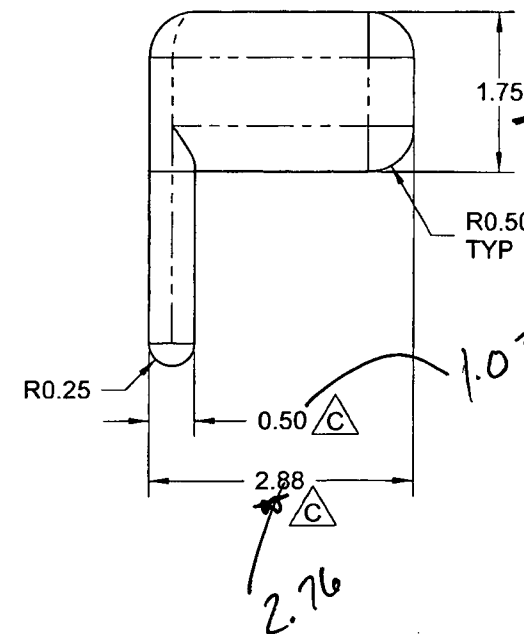
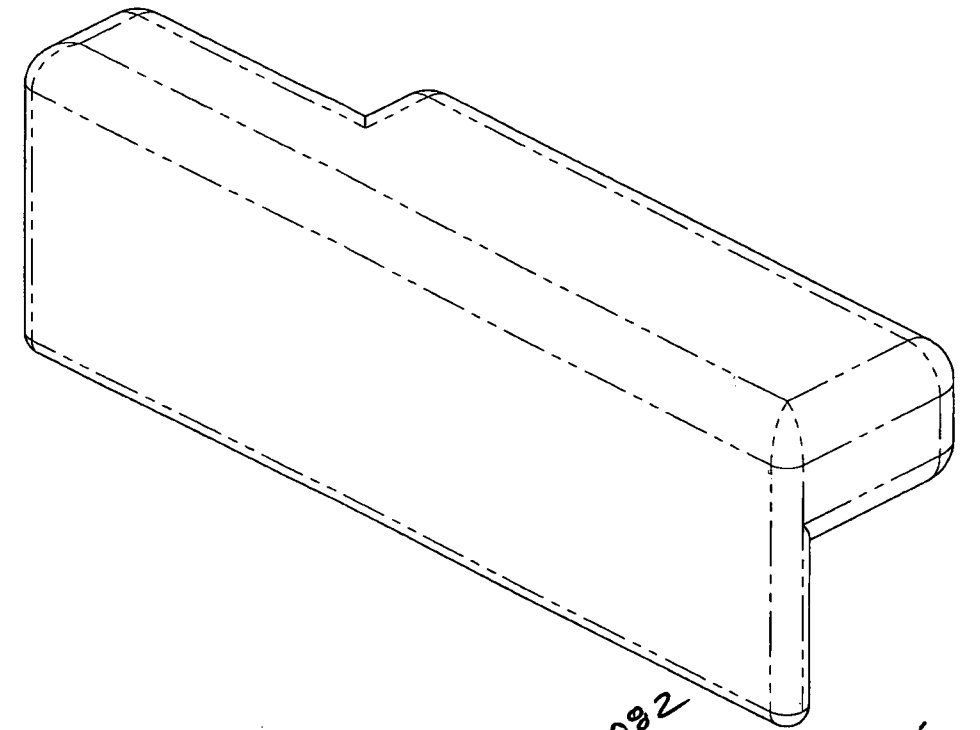
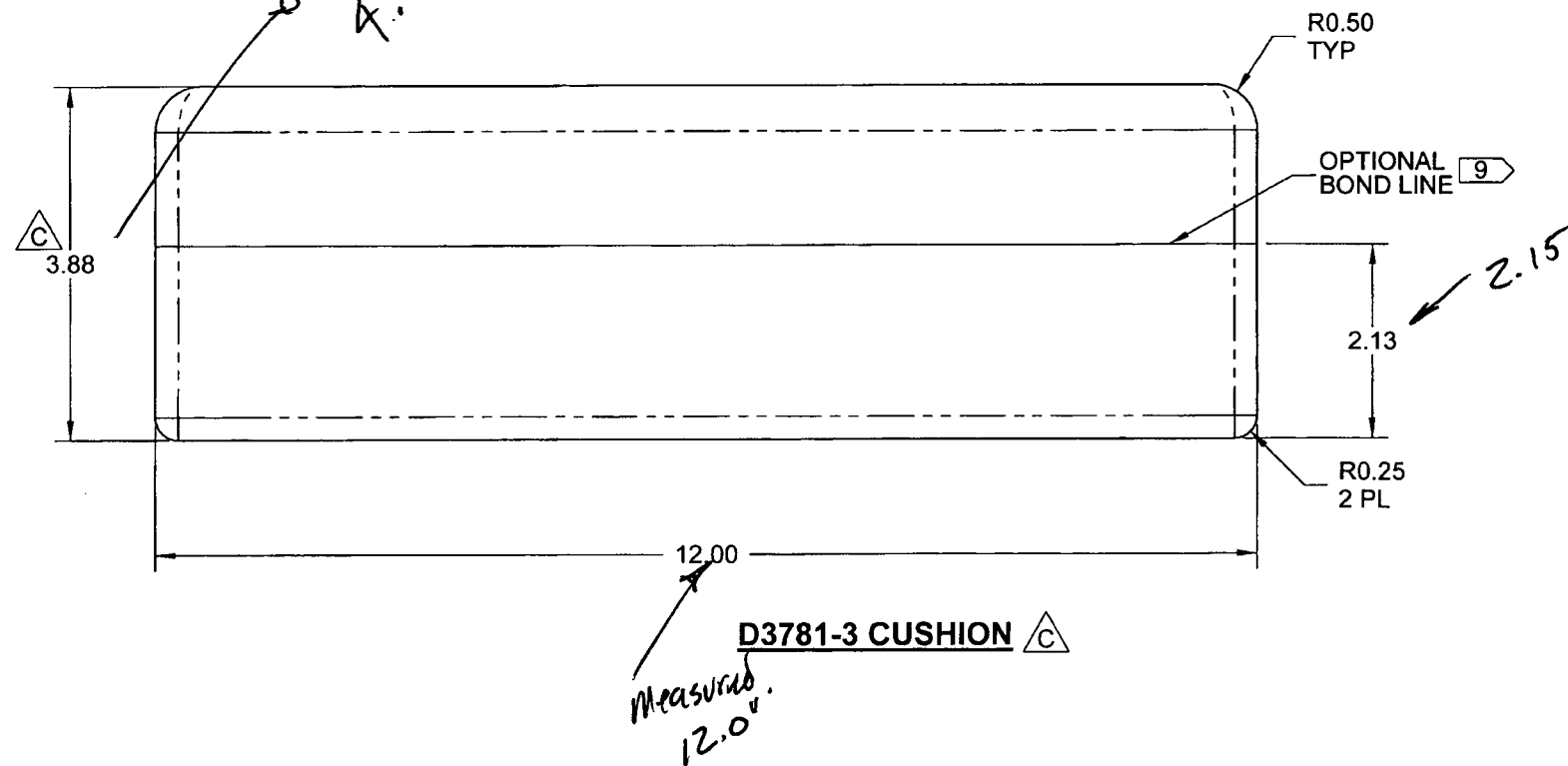
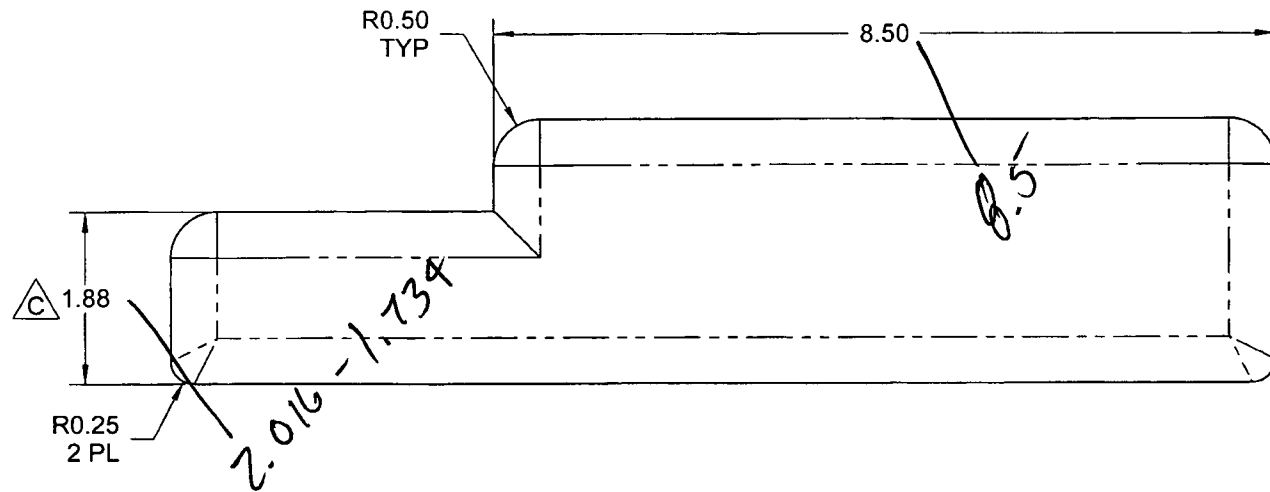


POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____


09.02.30



- Dimensions Very Difficult to Verify due to Material + D3781-1 installation +
- Radio impossible to Verify due to Seams + excess material.

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 1.75" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN ABOVE USING 3M 1300 SCOTCH-BRITE ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3781	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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Date	Packing Slip#
1/15/2009	5743

Invoice To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship Date	P.O. No.
-----------	----------

613.632.1053

Courier Acct No.

15179324-0

1/23/2009

7965

Part Number

Qty

D3781041

3

*SURREYSILVER SUNSET VINYL PN: SY-111
GST On Sales

RECEIVED JAN 30 2009

www.aerotextinteriors.com

GST/HST No. 139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order: 7965
Our Work Order: 5743

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL - SURREY SILVER SUNSET

FOAM - HR150

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH FAR 27.853(a) and 29.853(a)

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A handwritten signature in black ink, consisting of a series of loops and strokes, is written over a horizontal line.



5000 N. Highway 251 ■ Davis Junction, IL 61020
815.393.4600 ■ 800.945.7135
www.SkandiaInc.com

Client:
SKANDIA (PRODUCTS)
5000 N HWY 251
DAVIS JUNCTION IL 61020

WO #: 103975-04
Date: 01/28/04
Test Plan #:
PO #:

Aircraft:
STOCK

S/N:
NA

VERTICAL FLAMMABILITY TEST RESULTS

FAR 25.853 (a) Appendix F Part I (a) (1) (ii)

Conditioning Room: Time In: 01/26/04

Time Out: 01/28/04

Specimen: GEORGE N. JACKSON.: SURREY SILVER SUNSET.

Flame Application (seconds)	Flame Time (seconds)	Burn Length (inches)	Drippings (seconds)
12	1.3	2.8	0.0
12	0.0	3.1	0.0
12	0.0	3.1	0.0
Average:	0.4	3.0	0.0

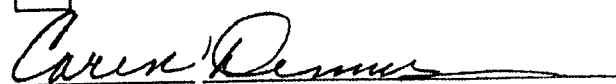
Comments:

Vertical (12 sec.) Burn Test: Average Self-Extinguish time may not exceed 15 sec. Average Burn Length may not exceed 8". Average Dripping may not exceed 5 sec. after falling.

Passed: ☒

Failed : ☐

Signed:


Carin Demus

12NW-50598



SKANDIA

5000 N. Highway 251 ■ Davis Junction, IL 61020
815.393.4600 ■ 800.945.7135
www.SkandiaInc.com

Client: Skandia (Products)
5000 N. Hwy. 251
Davis Junction IL 61020 USA

WO #: 177027-08
Date: 02/19/08
Test Plan #:
PO #:

Aircraft:
Stock

S/N: NA

Test ID #: 12NW-93054

VERTICAL FLAMMABILITY TEST RESULTS

14 CFR Part 25.853 (a) Amdt 25-116 Appendix F Part I (a)(1)(ii)

Conditioning Room: Time In: 02/18/08 2:30PM Time Out: 02/19/08 3:21PM

Specimen: Skandia, Inc.: HR Polyurethane Foam 150 ILD 1/2". Lot #02118-H150

Flame Application (seconds)	Flame Time (seconds)	Burn Length (inches)	Drippings (seconds)
12	0.0	3.2	0.0
12	0.0	3.6	0.0
12	0.0	3.1	0.0
Average:	0.0	3.3	0.0

Comments:

Vertical (12 sec.) Burn Test: Average Self-Extinguish time may not exceed 15 sec. Average Burn Length may not exceed 8". Average Dripping may not exceed 5 sec. after falling.


Passed:

☒

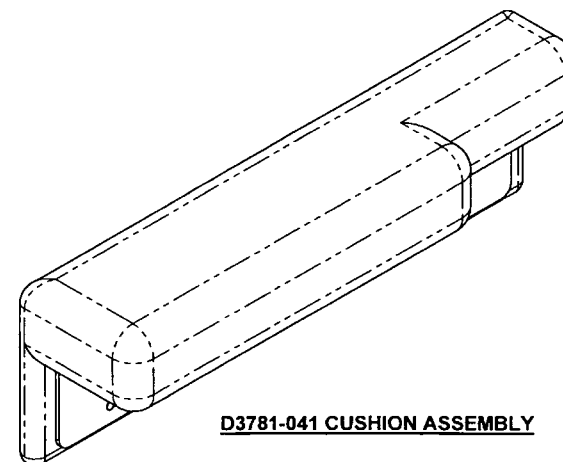
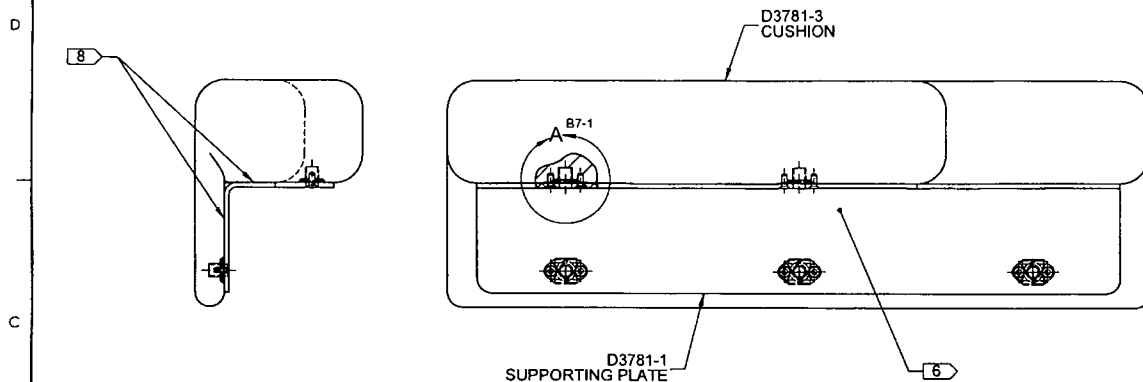
Failed :

☐

Signed:


Carin Demus

ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
13	1	D3781-3	CUSHION
21	10	MS20426AD3-4	RIVET
22	5	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE



D3781-041 CUSHION ASSEMBLY

RELEASED
07/02/05

D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

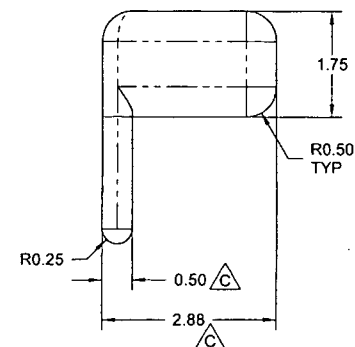
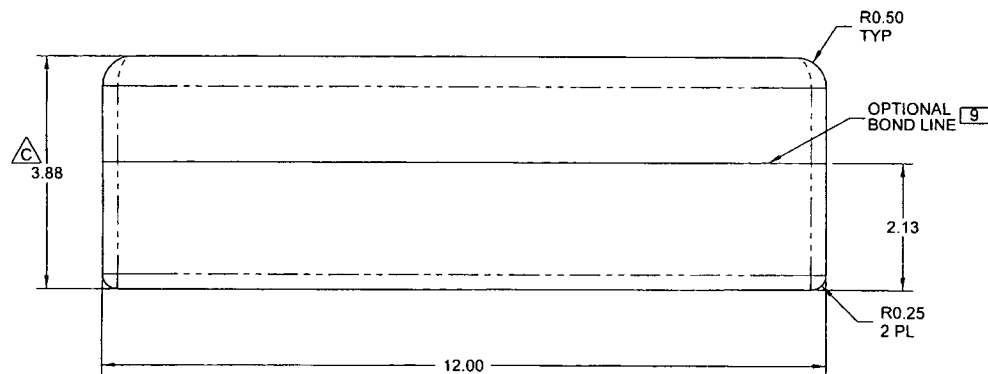
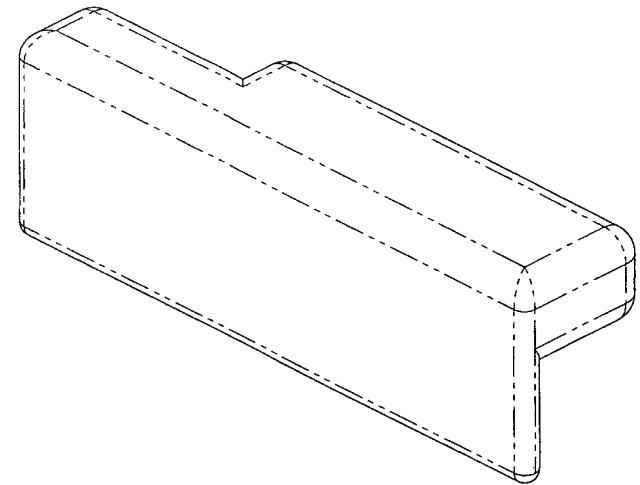
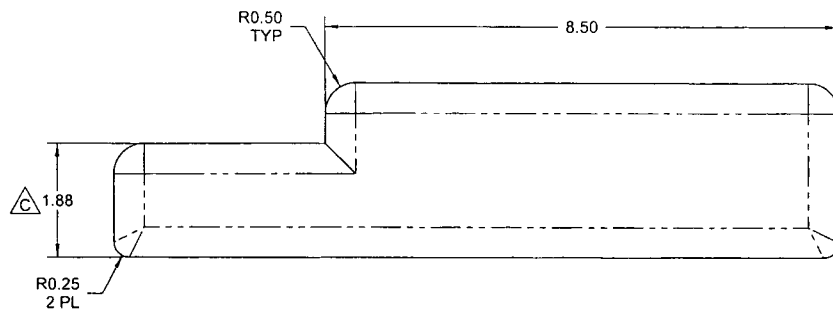
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	JB		
CHECKED	PH		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	08.11.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3781** REV. C
SHEET 1 OF 3

TITLE **CUSHION ASSEMBLY** SCALE
NTS

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D3781-3 CUSHION

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 1.75" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN ABOVE USING 3M 1300 SCOTCH-BRITE ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

44535

RELEASED
09/2/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3781	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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